

Work Order ID 119905

119905

Page 1

May-29-14 2:30:41 PM

Item ID: D205-634-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/13/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-05-30

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580-041	G

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG005

N/A MLJ 14-07-24

110

0.00

110

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

DEL J/K 14-6-11

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Item ID: D205-634-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/13/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for welding as per QSI 004

DGL

14-6-12

DAS
18
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

1

8

14-06-16

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Item ID: D205-634-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube Fits LH or RH
Start Date: 5/29/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/13/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
140									
Skidtubes									
Skidtubes	Memo	0.00							
	1-Weld step D2576 as per Dwg. D2580 and QSI004 A/R Aluminum Rod <i>m129285</i>			<i>BE 14-06-16</i>					
	2-Grind welds on step as per Dwg D2580								
	3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start expantion and finish with 1/2 x 18G to achieve dwg dimation.								
	4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr								
	6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr								
	7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr								
150									
150									
QC									
Quality Control	Memo	0.00							
	QC10- Inspect visual per QSI004- ground welds	0.00							
			DAS						
			27						
			9-89						
			<i>14/6/18</i>						

14-6-16 / L / DL

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Item ID: D205-634-041

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

160

QC

Memo

0.00

Quality Control

14/6/18

170

Pressure Wash per QSI005 4.3

0.00

170

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

1 7647-4

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30
320
9:00

1 14-79

DAS 34 9-89

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/13/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

100

QC

Memo

0.00

Quality Control

1x 4 11 10/07/16

DAS
15
9-89

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Item ID: D205-634-041

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00

200

HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 14129457

Sikaflex expire date: 11/11

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 RTU 598 13612 M125792 exp 15/06

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 14129457

Sikaflex expire date: 11/11

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 14129457

1x g 28 1407/12

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Item ID: D205-634-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Replacement Skidtube Fits LH or RH
Start Date: 5/29/14 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 6/13/14 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
220	Packaging	0.00							
220									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-634-041								
	Location: _____								
	PPP Rev: _____								
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

JUL 23 2014

DAS
06
9-89

MLJ 14-07-24

7-23

Picklist Print

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Work Order ID: 119905

119905

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
 KJ IPP Rev P 10.02.19
 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
 10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS
 PER ECN11-684 VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4202-1		Manufactured	No			140	Each	740.0000	20	20			
---------	--	--------------	----	--	--	-----	------	----------	----	----	--	--	--

D4202-1

Spacer

Location	Loc Qty	Loc Code
LG	737	
113770	101	
117096	236	
118978	400	
LG001	3	
105931	3	

20 14-6-16 JLM/ra

D2580-1		Manufactured	No			110	Each	10.0000	1	1			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2580-1

205 Bent Tube

Location	Loc Qty	Loc Code
LG	119069	
117898	6	
119306	4	

1 DEC 14-6-11

D2576-3		Manufactured	No			140	Each	43.0000	1	1			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2576-3

Step (Machining Detail)

Location	Loc Qty	Loc Code
LG	43	
112978	43	

1 8614-06-16

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 31.0000 1 1

D2855

Cap

HL 10/6/16

Location

Loc Qty

Loc Code

FP001

29

B11760Z

X1

105248

6

111897

23

ST019

2

10360

2

AN3-5A

Purchased

No

200

Each

320.0000

2

2

AN3-5A

Bolt

HL 10/6/16

Location

Loc Qty

Loc Code

GA

45

117423

45

ST511

185

m126559

92

m129246

93

ST512

90

124561

90

XZ

NAS1149D0332J

Purchased

No

200

Each

3,508.000

2

2

NAS1149D0332.J

Washer

HL 10/07/16

Location

Loc Qty

Loc Code

ST294

423

m128606

423

XZ

ST510a

3085

m128612

3085

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Work Order ID: 119905

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

119905

D205-634-041

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130 AELS8-1032-130 Purchased No

200 Each 9,500.000 50 50

AI S7-1032-130

Rivnut

ALS4-1032-130

**

Handwritten signature

Location

Loc Qty

Loc Code

FG

100

121444

100

ST553

9400

M128649

9400

Handwritten: 850

AN3C4A Purchased No

200 Each 2,950.000 50 50

AN3C4A

Bolt

**

Handwritten signature

Location

Loc Qty

Loc Code

FG

20

122814

20

Return2014

9

124221

9

ST350

13

125388

3

M128606

6

M128739

4

ST350/513

26

M128606

26

ST512

3

124221

3

ST513

2879

M127410

1

M127832

62

M128634

816

M128879

2000

Handwritten: 50

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Work Order ID: 119905

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

200

Each

5,750.000

50

50

NAS1149C0332R

WASHER

all u/o 7/16

Location

Loc Qty

Loc Code

GA

825

11129499

250

125654

825

Return2014

41

122063

41

ST292

1726

124580

8

125654

8

m128591

1710

st510

3158

m126319

61

m127306

2500

m127410

563

m127831

34

D3566-13

Manufactured

No

200

Each

19.0000

1

1

D3566-13

Gasket Fwd

all u/o 7/16

Location

Loc Qty

Loc Code

FG

4

13119343

250

89050

4

FP001

15

114917

3

116747

12

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Work Order ID: 119905

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured No

200

Each

30.0000

1

1

D3566-5

Gasket Center Aft

**

all valve

Location

Loc Qty

Loc Code

FG

4

13120309

x1

89219

2

94119

2

FP001

25

109492

1

116946

12

118931

12

ST

1

116649

1

D3566-1

Manufactured No

200

Each

29.0000

2

2

D3566-1

Gasket Fwd & Aft

**

all valve

Location

Loc Qty

Loc Code

FG

14

13120350

x2

100410

4

117012

4

89051

2

96430

2

98981

2

FP001

15

109785

1

117012

1

118946

13

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Work Order ID: 119905

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

D3564-11 Manufactured No 200 Each 9.0000 1 1 ** all 11/03/16

D3564-11
Stainless Steel Wearplate Aft

Location	Loc Qty	Loc Code
FG	6	B120675
77056	4	
85473	2	
FP001	3	
115694	3	

D3564-13 Manufactured No 200 Each 31.0000 1 1 ** all 11/03/16

D3564-13
Stainless Steel Wearpad Fwd

Location	Loc Qty	Loc Code
FG	2	
89044	2	
FP001	5	
114335	5	
FP002	24	
117119	12	
118990	12	X1

D3564-9 Manufactured No 200 Each 10.0000 1 1 ** all 11/07/16

D3564-9
Stainless Steel Wearplate Fwd

Location	Loc Qty	Loc Code
FG	6	B118956
76950	4	X1
88407	2	
FP001	4	
115774	1	
117036	3	

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Picklist Print

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Work Order ID: 119905

119905

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

26.0000

1

1

D3564-5

Stainless Steel Wearplate Center Aft

all 2x107112

Location

Loc Qty

Loc Code

FG

3

B119385

34806

1

89048

2

FP001

10

115655

10

FP002

13

116815

13

D2594-3

Manufactured No

200

Each

1,065.000

16

16

D2594-3

O-Ring

all 1x107111

Location

Loc Qty

Loc Code

FP001

1065

108402

156

110671

2

112234

3

113590

404

117822

500

D2594-1

Manufactured No

200

Each

318.0000

16

16

D2594-1

Plug

all 1x107114

Location

Loc Qty

Loc Code

FP001

301

112516

60

112727

32

115139

209

FP002

17

106252

17

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LIST OF MATERIALS						PART NUMBER	DESCRIPTION
ITEM	QTY -041	QTY -045	QTY -047	QTY -049			
1	X					D2580-041	SKIDTUBE ASSEMBLY
2		X				D2580-045	SKIDTUBE ASSEMBLY
3			X			D2580-047	SKIDTUBE ASSEMBLY
4				X		D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1		D2500-1-190	EXTRUSION
21			16	16		D2570	BUSHING
22	1	1	1	1		D2576-3	STEP
23		4				D2579	SPACER
24	16	16	8	8		D2594-1	PLUG
25	16	16	8	8		D2594-3	O-RING
26	1	1	1	1		D2596	205 WEB
27	1	1	1	1		D2855	AFT CAP
28	1	1				D3564-5	WEARSHOE
29	1	1				D3564-9	WEARSHOE
30	1	1				D3564-11	WEARSHOE
31	1	1				D3564-13	WEARSHOE
32	2	2				D3566-1	GASKET
33	1	1				D3566-5	GASKET
34	1	1				D3566-13	GASKET
35	20	20	24	24		D4202-1	SPACER
36			1			D4406-041	WEARPLATE ASSEMBLY
37			1			D4406-043	WEARPLATE ASSEMBLY
37				1		D5061-1	FWD WEARPLATE
37				1		D5061-3	AFT WEARPLATE
50	50	50				ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50				AN3C4A	BOLT
52	2	2	2	2		AN3-5A	BOLT
53			8	8		AN4-45A	BOLT
54	50	50				NAS1149C0332R	WASHER (AN960C10L)
55	2	2	2	2		NAS1149D0332J	WASHER (AN960JD10L)
56			8	8		MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

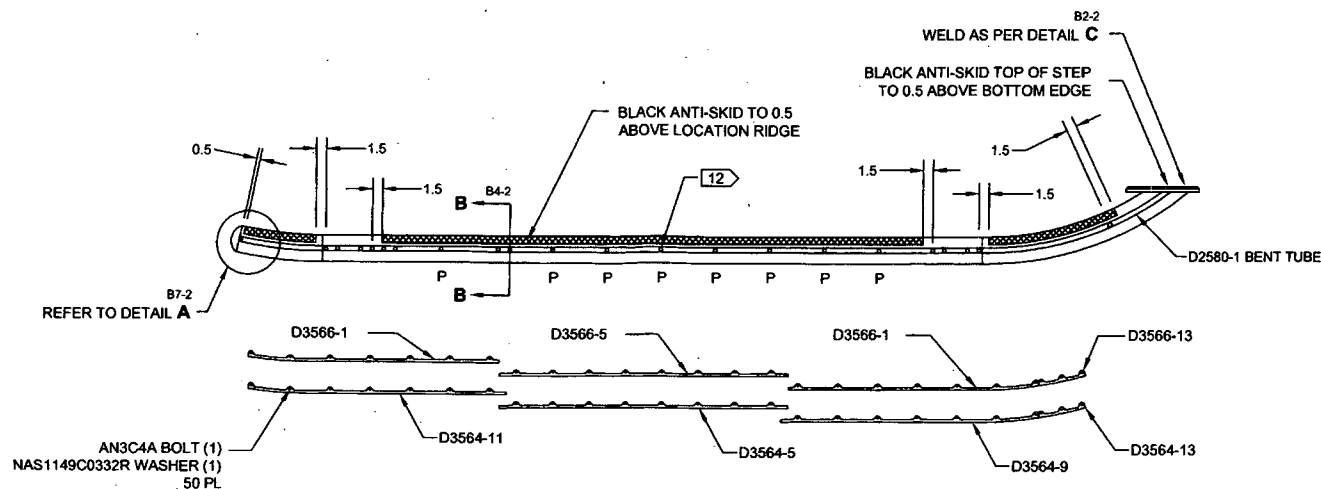
- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER
COAT ASSEMBLY (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT ASSEMBLY (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.287 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

RELEASED
2014-04-29

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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 119905 MCT
1405-38

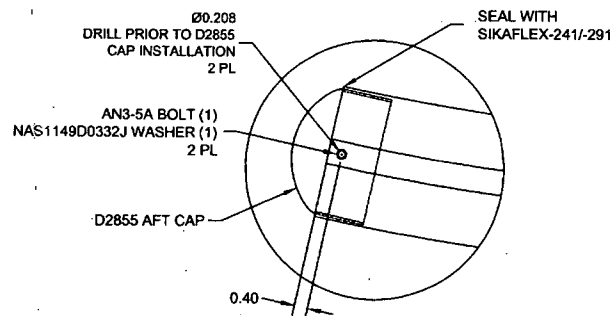
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9598	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.	DS	D2580	SHEET 1 OF 9
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	205 SKIDTUBE ASSEMBLY	NTS
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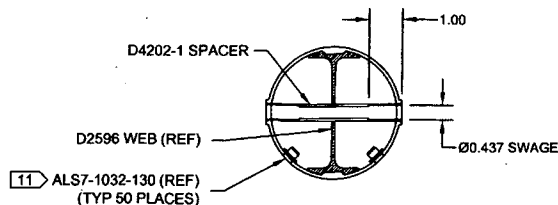
D2580-041 ASSEMBLY DETAIL

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2014-04-29

DETAIL A C7-2
SCALE 5X

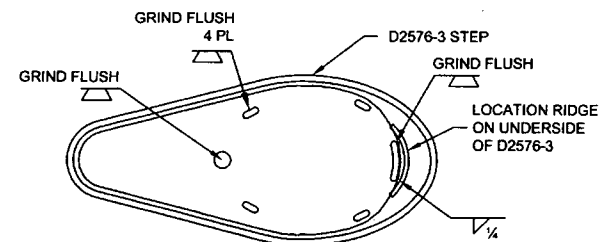


SECTION B-B D5-2
SCALE 5X

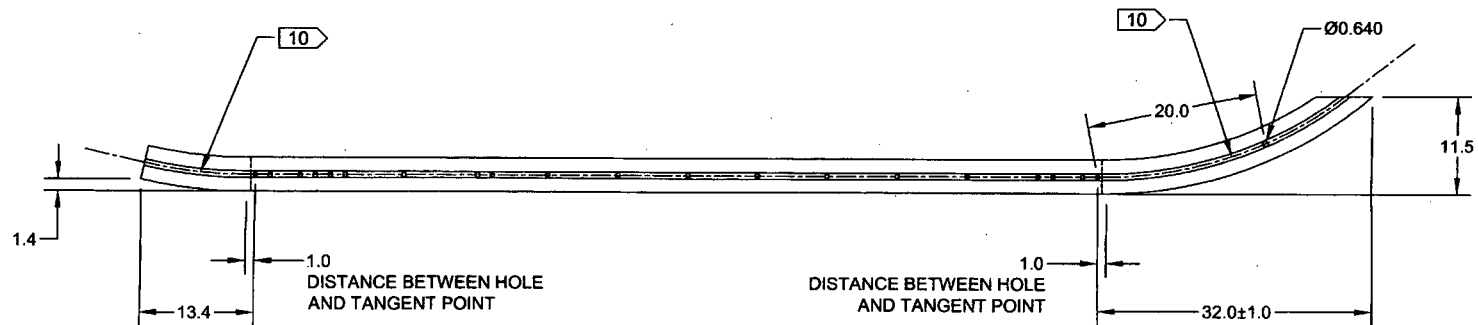


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

DETAIL C D3-2
SCALE 5X



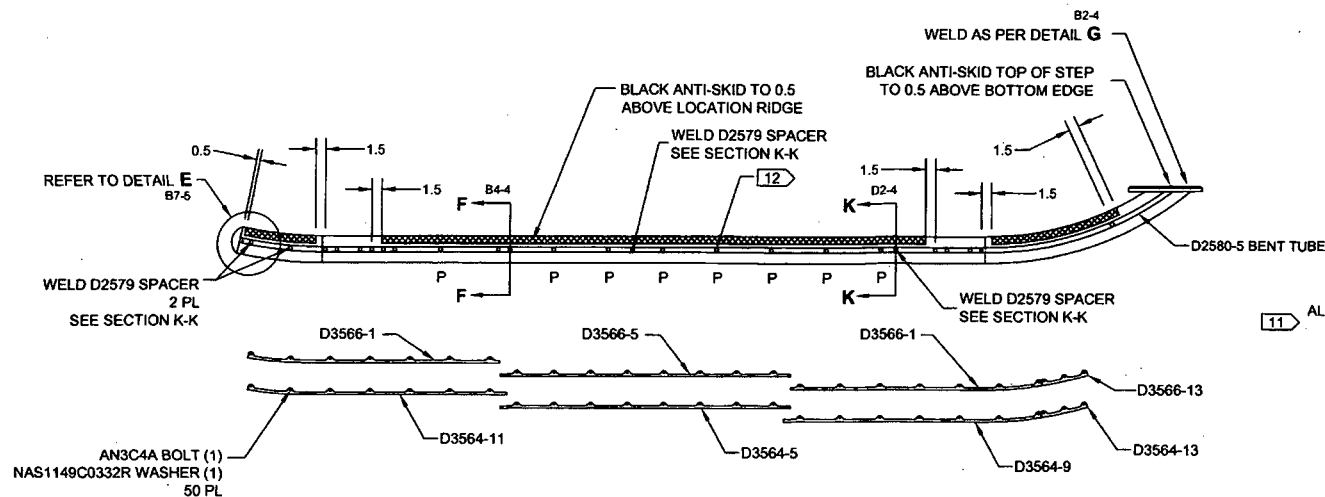
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

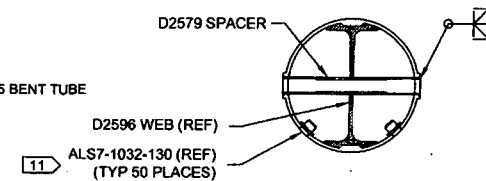
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DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 3 OF 9
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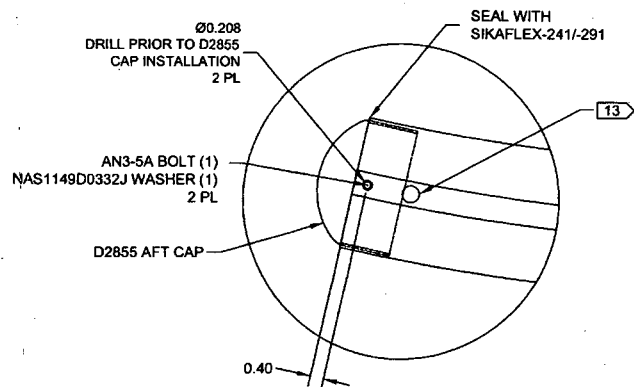
D2580-045 ASSEMBLY DETAIL

SECTION K-K D5-4
SCALE 5X

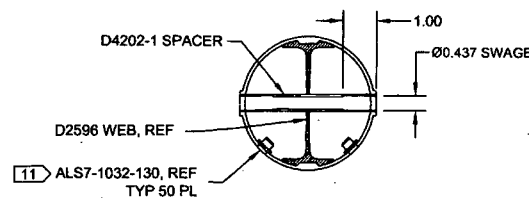


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

DETAIL E D7-4
SCALE 5X

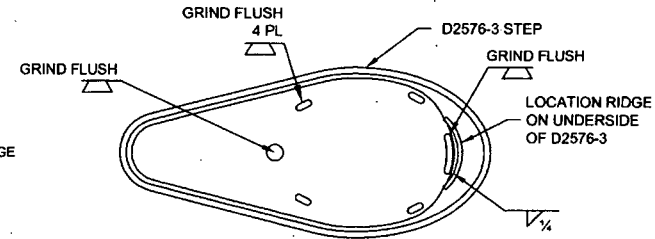


SECTION F-F D5-4
SCALE 5X

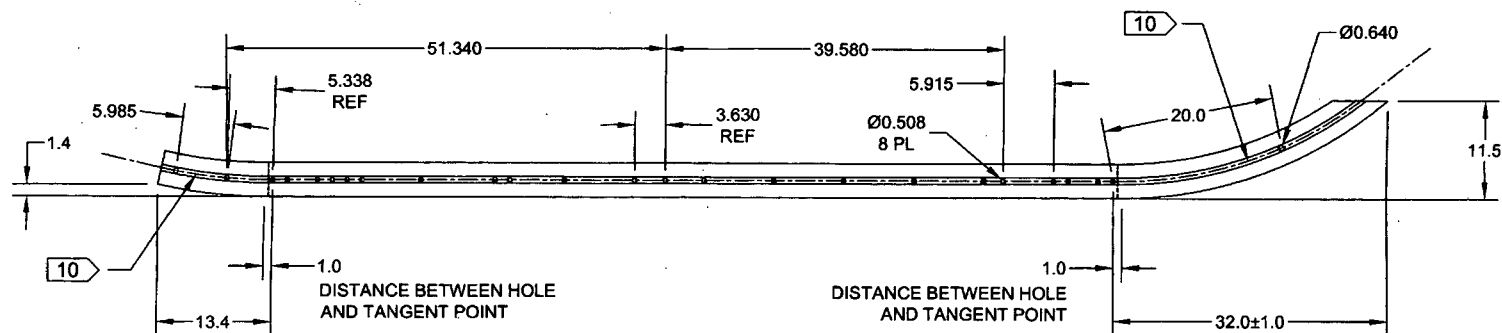


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

DETAIL G D3-4
SCALE 5X



DESIGN	DS	DART AEROSPACE LTD	
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CHECKED	AJS	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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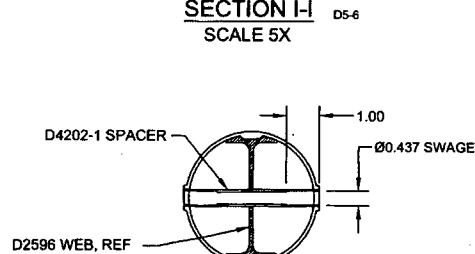
D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>AJS</i>	D2580	SHEET 5 OF 8
APPROVED	<i>AJS</i>	TITLE	SCALE
DE APPR.	<i>AJS</i>	205 SKIDTUBE ASSEMBLY	NTS
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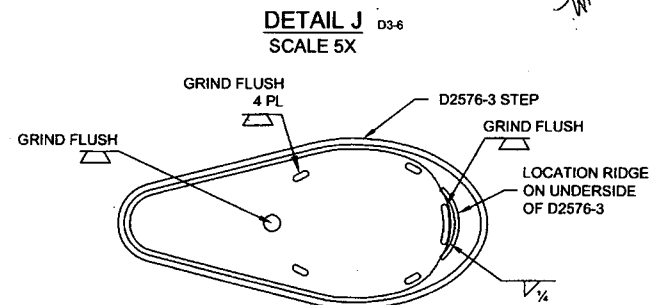


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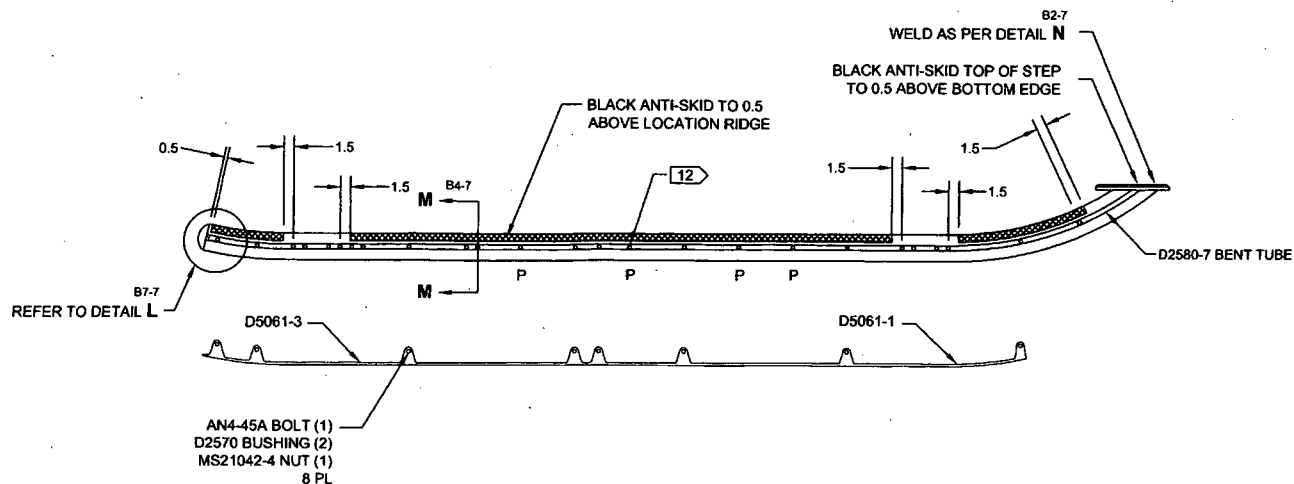


**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

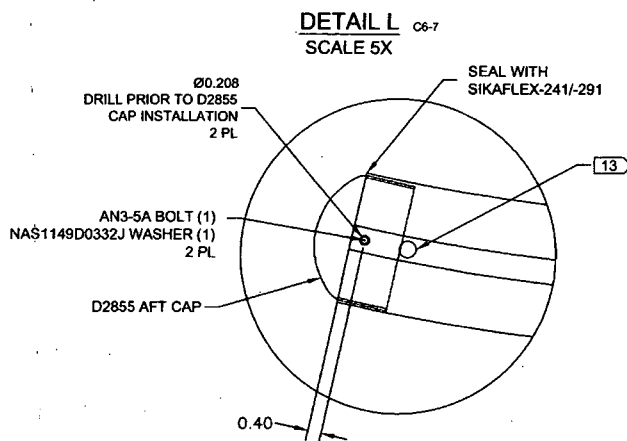
- 1. INSERT D4202-1 SPACER (24 PLACES)**
- 2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002**
- 3. TRIM/GRIND FLUSH PER QSI 002**



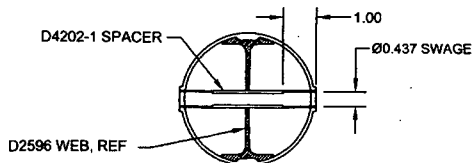
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>MA</i>	D2580	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NT
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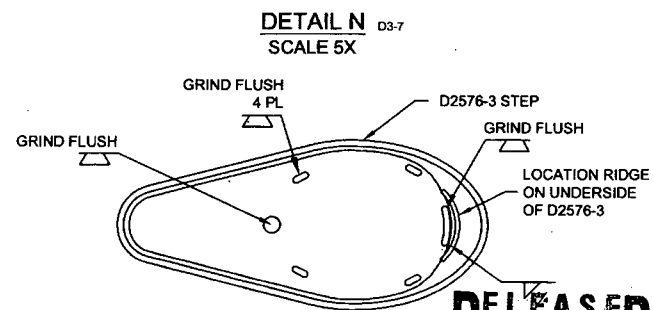
D2580-049 ASSEMBLY DETAIL



SECTION M-M D5-7
SCALE 5X

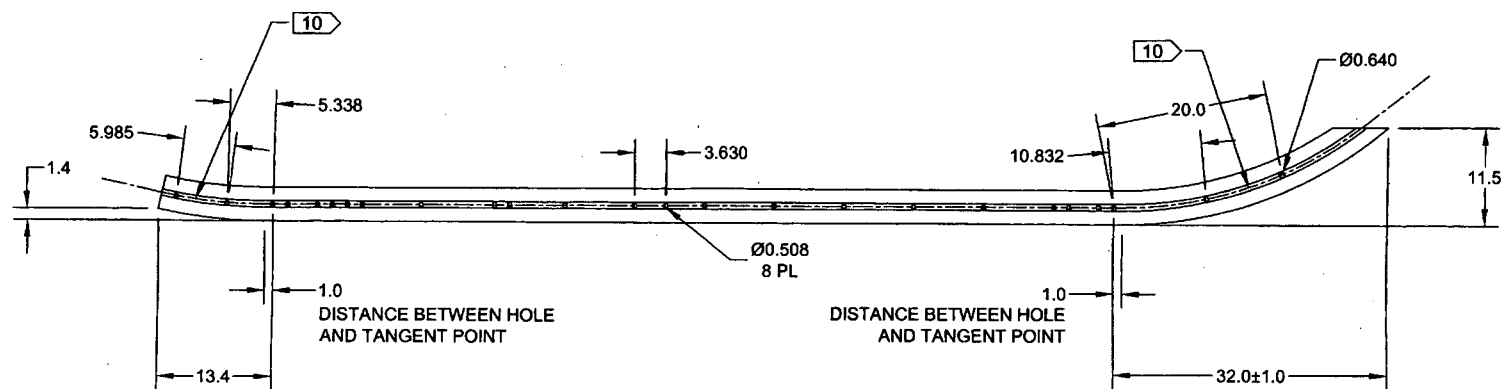


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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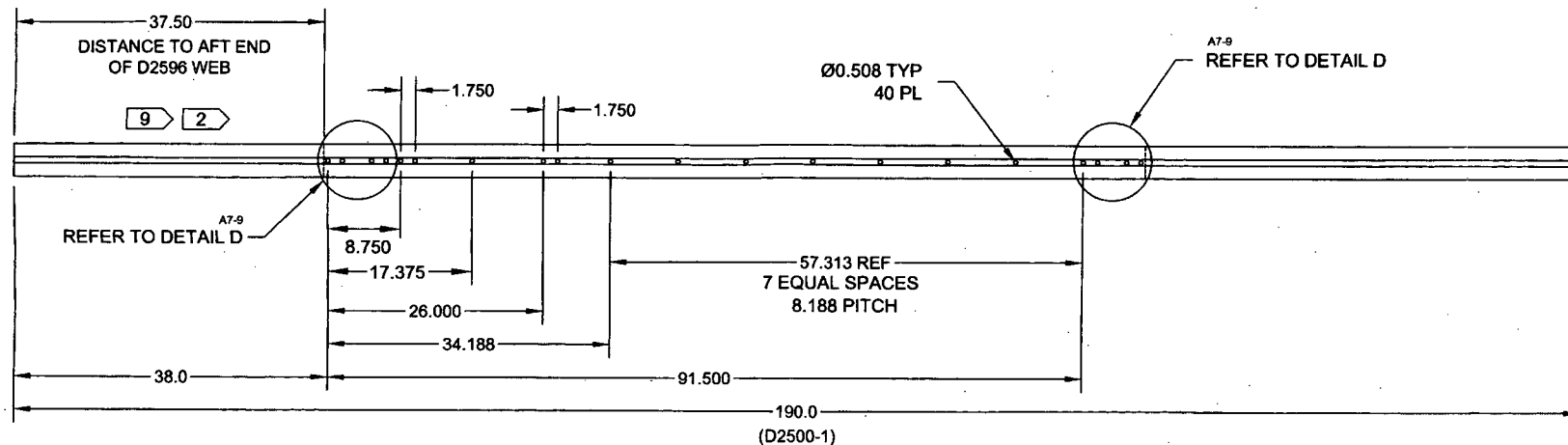
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 7 OF 9
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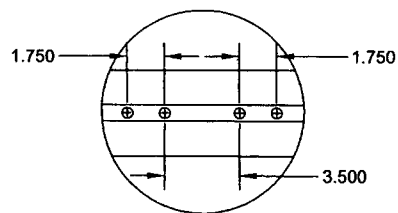
D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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MFG. APPR.		D2580	SHEET 8 OF 9
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D2580-101 TUBE



DETAIL D
SCALE 5X

C3-9
C7-9

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CHECKED	<i>A.P.</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>A.P.</i>	D2580	SHEET 9 OF 9
APPROVED	<i>WFO</i>	TITLE	SCALE
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